Work Order I June-16-14 8:50:13			*120	1931*		7	,375			Page 1
Revision ID:	564-11 nless Steel Wearplate Aft		Accept	*N900	040	100	7* s	Setup Sta	rt *N	S1*
Start Date: 6/16 Required Date: 6/16 Reference:				Cust Item l Customer:	D:				I	. 7/
	ocess Plan: MUS	Date: 1406-16	Tooling: SPC (Y/N):		ate:		R	Run Sta Sto	/ ^	R1* R2*
Sequence ID/ Work Center ID	Operation Description	ابر .	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3564	Rev D									
100 *1 \\ Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as p Rev:	er Dwg D3564 *****(D3564) 2-Deburr if necessary	0.00 0.00 -1F)*****Dwg Rev:_	Prog			_15	B	14-6	-/-
*110 *110* QC Quality Control	QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				_15		1467	<u> </u>
120 *1 	QC8- Inspect parts - se	econd check	0.00 14/6/17	0AS 27 9-89			(13) cont			

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i dici	•0.					Use-as-is			noforming	Finishing		re/Packaging	
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	\vdash	Centre No	ot Concer	ntric	-	Broken/Damage/Defect	\vdash	Hardwa	aro.		Part Incorre		Temperature/Cure
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	\vdash	Crushing Heat Trea	+		-	Cut Too Short	-	Mislabe	•		Power Loss	_	Other
	-	Inspection		Tube	\vdash	Drawing		Misread			L	, O-	
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ı	1												
	\vdash	Turning S			-	Finish		4	Calibration				

Work Ord June-16-14 8:5		0931		*120	931*							Page 2
Item ID: Revision ID: Item Name:	D3564-11 Stainless Stee	l Wearplate Aft		Accept	*N900	0040	100)*	Setup	Start Stop	171	S1*
Start Date: Required Date: Reference:	6/16/14 6/16/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item Customer:	-						. 17
Approvals:	Process Pla	nn:	Date:	Tooling:	Γ	Date:	_		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):		Date:				Stop		R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Code	Accept	t Rej Qty		Reject Number	Insp. Stamp
130 Brake NC		NC BRAKE Memo		0.00			DAS 30 9-89	15				14/0
Brake NC			essaryForm on Brake as pe		s DT8179							
140 *1 4 0 * QC Quality Control		QC5- Inspect part comple Memo	teness to step on W/O	0.00	ohf obs			B				

150

150 Large Fab

Large Fab

Large Fab

Oty Description BatchA/R

M 129694 Weld hardcoat as per Dwg D3437

2059B Hardcoat

x15 27e 14.08.08

0.00

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DQA:			_ Date:								,		"DART
- QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		ork Order up	odate only	AEROSPACE
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Work Orde	er:					DISPOSITION				AGAINST DI	- -	/FROCE33	
	•					Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	-	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	١o.					Suspected Unapproved			Large Fab	Composite		Supplier	
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		Centre N	ot Concer	ntric		BOM/Route	-	Grain		.	Over/Under Part Incorre		Temperature/Cure
		Cracks	1 /5: 1			Broken/Damage/Defect	\vdash	Hardwa	are :ion Incomplete/Un	- Lauslified	Part Lost/M		Weld
	-	Crimp/Kii	nk/Rippie	e/wave	-	Burrs	\vdash	4 '	tions Incomplete/U	· -	Part Moved	issing	Wrong Stock Pulled
	-	Cuffs			┢	Contamination Countersink	\vdash	4	gned/off center	licieal	Positioned V	L_ Wrong	
	<u> </u>	Crushing Heat Trea				Cut Too Short	H	Mislab	-		Power Loss/		Other
	H	Inspectio		Tuba	\vdash	Drawing	\vdash	Misrea			٦. ٥٣٥، ٢٥٥٥/		_1
	-	Marks/Cl	· ·	·	\vdash	Drill Holes		Off-set					
	\vdash	Turning S				Finish	\vdash	-	Calibration				
	Т	Wave/Tw				Fit/Function		-	Sequence				

120931

Page 3

June-16-14 8:50:13 AM Accept Item ID: D3564-11 *N900040100* Setup Start **Revision ID:** Item Name: Stainless Steel Wearplate Aft *16* Start Date: 6/16/14 **Start Otv: 16.00 Cust Item ID:** Required Date: 6/16/14 Rea'd Otv: 16.00 *16* **Customer:** Reference: Start Run Process Plan: Date: Tooling: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Oty Otv Number Stamp 160 QC10- Inspect visual per QSI004- ground welds 0.00 *160* DAS BC-BC-M QC 0.00 Memo 9-89 Quality Control 170 QC5- Inspect part completeness to step on W/O 0.00 DAS *170* 14-08-08 OC 0.00 Memo Quality Control 180 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 DAS 41 *120* 125028 15 Powdercoat 0.00 Memo 14-8-12 Powder Coating 405 OVEN TEMPERATURE: START TIME: 320 FINISH TIME:

DQA:			Date:							ND 4 TE	•		DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFOI	RMANCE / UF		ork Order up	odate only	AEROSPACE
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Root					Desc	ription of work order update	1	nitial	Acti		Sign &		
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3/ 1	٦	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
r.	٦	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí [Temperature/Cure
KS 2	٦	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld
	一	Cuffs				Contamination		Instruct	tions Incomplete/L	Jnclear	Part Moved	Ĺ	Wrong Stock Pulled
	7	Crushing				Countersink		Misalig	gned/off center		Positioned \	Vrong	
		leat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		nspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	atter			Drill Holes		Off-set			***		
]	Turning S	equence			Finish		Out of	Calibration				
1	7	Wave/Tw	ist in Tuk	oe e		Fit/Function		Out of	Sequence				

Work Order ID	12093
June-16-14 8:50:13 AM	

10001

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June-16-14 8:5	0:13 AM			~12(19.31^	WT7-1.						Page 4
Item ID: Revision ID: Item Name:	D3564-11 Stainless Stee	el Wearplate Aft		Accept	*N900	040	100	ገ*	Setup	Start Stop	177	S1*
Start Date: Required Date: Reference:	6/16/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item I Customer:	D:					"IV.	7/"
Approvals:		an:		_ 0 _		ate:	_		Run	Start Stop		31* 32*
Sequence ID/ Work Center II 190 *1 OO* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
200 *200* Packaging Packaging		Identify as per dwg & Sto Memo	ck Location: FP &	32 _{0.00}				<u> </u>	· >		IJ	<u>l 1108</u>
210 *91		QC21- Final Inspection -	Work Order Release	0.00				_ML	.5_	(\	1-08-	1(
t									Mu	.3:1		

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						WORK ORDER NON	-CC	ONFO	RMANCE / UF			-		AEROSPACE
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Root					Desc	ription of work order update	Ī	nitial	Acti	on	Sign &			•
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		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing		Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V			
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
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		Marks/Ch	natter			Drill Holes		Off-set			-			
		Turning S				Finish	_	4	Calibration					
	1	Wave/Tw	<u>/ist in T</u> ub	oe		Fit/Function	\perp	Out of	Sequence					

Page 1

Work Order ID: 120931

120931

Parent Item:

D3564-11

D3564-11

Parent Item Name: Stainless Steel Wearplate Aft

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev:D

Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	416.8070	1.41	24	· · · ·		
M304S16	SGA								**	Ø	14-6-	16	

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code	
MAT020	416.807		
M127821	75.567		
M128423	1.2		
M129192	20.04		
M129449	320		_/_

DQA:			Date:										TAAG
						WORK ORDER NON-	-C(ONFO	RMANCE / UP				AEROSPACE
QA Closed:			Date:		,					V	Vork Order up	date only	
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Work Orde	٠	-				Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	ο.					Scrap		ĺ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing		e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desc	ription of work order update	ı	Initial	Action	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
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	-	Cracks Crimp/Kir	k/Pinnio	Mayo	-	Burrs		4	ion Incomplete/Un	qualified -	Part Lost/Mi	 	Weld
}	-	Cuffs	ik) vihhie	y wave	-	Contamination		4	tions Incomplete/U		Part Moved	- T	Wrong Stock Pulled
}		Crushing				Countersink	\vdash	4	gned/off center	-	Positioned V	∟ Vrong	
\	-	Heat Trea	ıt			Cut Too Short	-	Mislabe			Power Loss/		Other
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	$\overline{}$	Marks/Ch	· -		-	Drill Holes	\vdash	Off-set					
		Turning S			 	Finish	\vdash	-	Calibration				
		Wave/Tw				Fit/Function	厂	-	Sequence				

DART AEROSPACE LTD	Work Order: 120931	
Description: Wearshoe	Part Number: D3564-1	11
Inspection Dwg: D3564 Rev: D	Page 1 o	f 1

FIRST ARTICLE INSPECTION CHECKLIST

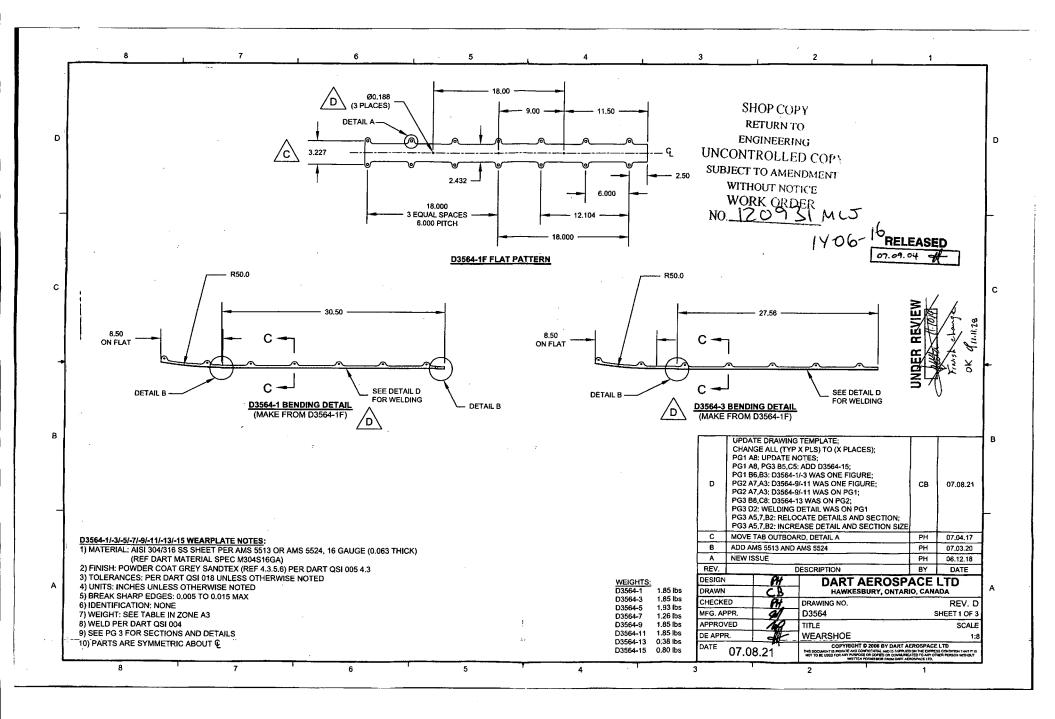
X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.221	/			
2.432	+/-0.010	2.439	~			
2.50	+/-0.030	2.25	/			
6.000	+/-0.010	6				
12.104	+/-0.010	12-164	/			
18.000	+/-0.010	18				
18.00	+/-0.030	18				
9.00	+/-0.030	9				
11.50	+/-0.030	11.5				
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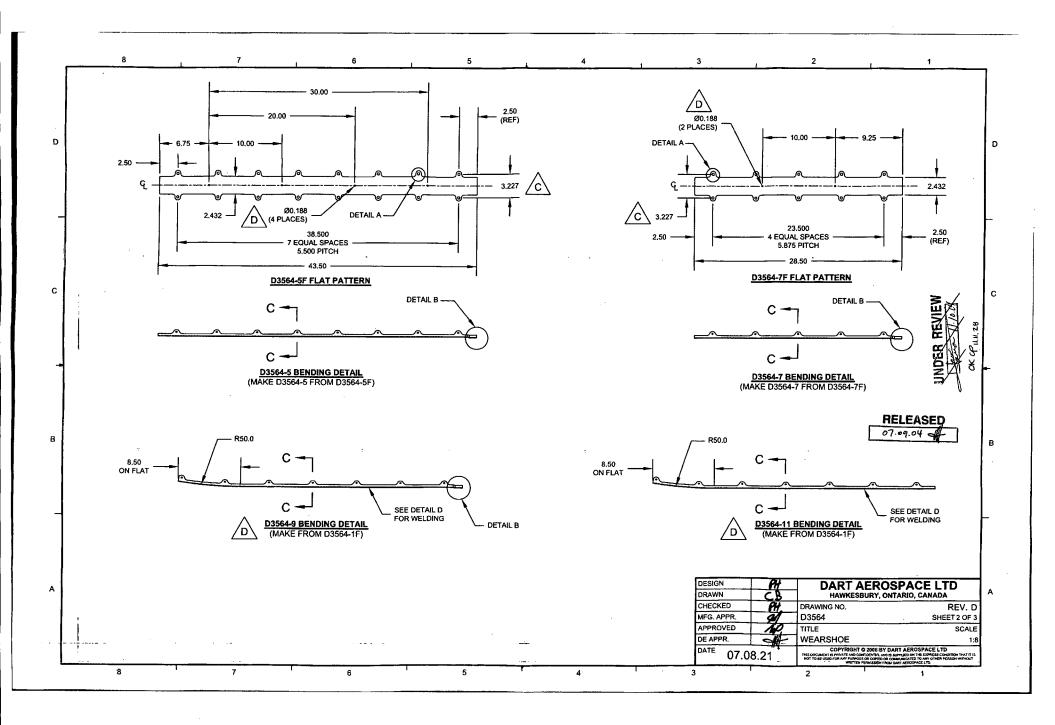
			DAS	 · .	
Measured by:	Q A	Audited by:	, The same of the	Prototype Approval:	N/A
Date:	4-6-16	Date:	14/6/17 9-89	Date:	N/A

A 07.09.06 New Issue	14 1/11 5 5	
	KJ/JLM	
B 07.11.23 Dwg Rev updated	KJ/EC/DD	1

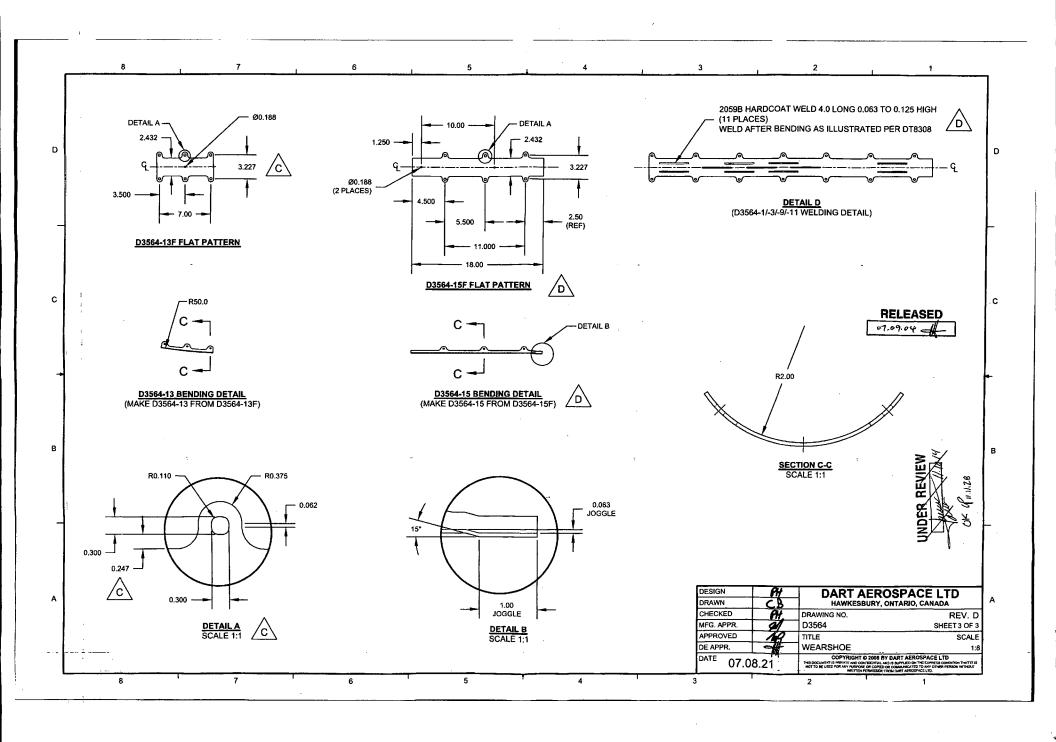
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Part N	lo.			_		Scrap			Machining Small	Fab	4	d. Eng. Coor.	Quality
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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	L	Cuffs			<u> </u>	Contamination	<u></u>	-	tions Incomplete/Unclear	<u> </u>	Part Moved	L	Wrong Stock Pulled
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		Turning S	•		L	Finish		-	Calibration				
		Wave/Tw	ist in Tul	oe -		Fit/Function		Out of	Sequence				



DQA:			Date:										10	DART	
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:					.		W	ork Order up	odate only			
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Part N	No.					Scrap			Machining Small Fa		Pro	d. Eng. Coor.		Quality	
	•					Use-as-is	1	Therr	noforming Finishir	ng[_	Rec/Sto	re/Packaging		Other	
NCR I	NCR No.				Suspected Unapproved]	Large Fab Composite]	Supplier				
Root					Desc	ription of work order update		Initial	Action	-	Sign &				
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	<u> </u>	Cracks			ļ	Broken/Damage/Defect	<u> </u>	Hardwa		┝	Part Incorre	⊢	_	mperature/Cure	
	<u> </u>	Crimp/Kink/Ripple/Wave				Burrs	\vdash	4	ion Incomplete/Unqualified	\vdash	Part Lost/M	ssing	-\\\\\		
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J	1	Wave/Tv	vist in Tul		Fit/Function		Out of	Sequence							



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		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	oe		Fit/Function			Sequence					